

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004540**Date Inspected:** 04-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

On this day Caltrans Assurance Inspector (QA) Larry Viars was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Assembly Bay 2:

QA performed Phased Array Ultrasonic Testing (PAUT) after Caltrans NDE technicians performed the preliminary scan with conventional Ultrasonic Testing (UT) in the tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plates. This QA inspector performed PAUT on DP243-001 in the areas that exhibited crack like indications with conventional UT and PAUT of repair areas for DP109-002. This QA inspector recorded and gave information of repair PAUT for DP109-002 to Mark Wright. PAUT results were not recorded for DP243-001 because PAUT was not completed. Below is a summary of results of PAUT testing performed this night.

DP-109-002: (PAUT) Repair 1

Weld# 1 – 5 tacks PAUT'ed – 0 indications found noncompliant
Weld# 2 – 3 tacks PAUT'ed – 0 indications found noncompliant
Weld# 3 – 4 tacks PAUT'ed – 0 indications found noncompliant
Weld# 4 – 4 tacks PAUT'ed – 0 indications found noncompliant
Weld# 5 – 3 tacks PAUT'ed – 0 indications found noncompliant
Weld# 6 – 5 tacks PAUT'ed – 0 indications found noncompliant

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Weld# 7 – 4 tacks PAUT'ed – 0 indications found noncompliant

Weld# 8 – 4 tacks PAUT'ed – 0 indications found noncompliant

DP-243-001: (PAUT) Initial

Weld# 2 – 1 tack PAUT'ed – 0 indications found noncompliant

Weld# 3 – 1 tack PAUT'ed – 0 indications found noncompliant

Weld# 4 – 1 tack PAUT'ed – 0 indication found noncompliant

Weld# 5 – 1 tack PAUT'ed – 1 indication found noncompliant

Weld# 6 – 3 tacks PAUT'ed – 2 indications found noncompliant

Weld# 8 – 3 tacks PAUT'ed – 1 indications found noncompliant

Weld# 9 – 1 tack PAUT'ed – 0 indications found noncompliant

Weld# 10 – 2 tacks PAUT'ed – 0 indications found noncompliant

NOTE: Phased Array testing was performed in accordance with specification, UT 04-012024.

No other observations were made.

Summary of Conversations:

Only general conversations between Caltrans QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
